

Work Order ID 86358

86358

Page 1

June-27-12 3:45:29 PM

Item ID: D2175-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Angle RH

Start Date: 27/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/28 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2175	Rev E								
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2175								
2024.063	Dwg Rev: <u>E</u>								
	Prog Rev: <u>E</u>								
	2-Deburr if necessary								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

4 0 Jm 12-7-7

4 0 Jm 12-7-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Required Date: 11/07/2012 Req'd Qty: 4.00

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Small Fab

0.00

130

Small Fab

Memo

0.00

Small Fab

Deburr Stack

140

NC BRAKE

0.00

140

Brake NC

Memo

0.00

Brake NC

Form as per Dwg D2175

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Page 3

Setup Start *NS1*

Stop *NS2*

Customer:

Run Start *NR1*

Stop *NR2*

SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

0.00

0.00 0 12/07/10

④ 4

0.00

0.00

Memo

4 HG 12-7-11

0.00

0.00

Memo

H ϕ BL 127-11

W/O:		WORK ORDER CHANGES					
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Page 4

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: _____	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

PC 12/7/12 (4)

MLJ 12/07/12

MLJ 12/07/12

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Picklist Print

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Page 1

Work Order ID: 86358

86358

Parent Item: D2175-2

D2175-2

Parent Item Name: Angle RH

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP E04.06.09ReformatKJ/RF

IPP Rev:F 06-04-28 Manufactured on Water Jet JLM

IPP Rev:G As per Rev E 06-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	245.3900	0.4722	1.988211			

M2024T3S 063

2024-T3 .063 sheet

**

Jm 12-7-7

Location

Loc Qty

Loc Code

MAT022

245.39

119916

72.85

121197

172.54

119916

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DART AEROSPACE LTD		Work Order:	86358
Description: Angle		Part Number:	D2175-1/-2
Inspection Dwg: D2175 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.650	+/-0.010	12.650	✓		MT	H301
R0.35	+/-0.030	0.35"	✓		RG	
2.915	+/-0.010	2.915"	✓		✓	mm01
50°	+/-0.5°	50°	✓		Protractor	
0.300	+/-0.010	0.303"	✓		✓	mm01
1.050 Pitch	+/-0.010	1.051"	✓		✓	"
10.500	+/-0.010	10.502"	✓		✓	Protractor
11.550	+/-0.010	11.553"	✓		✓	"
0.550	+/-0.010	0.551"	✓		✓	mm01
0.900	+/-0.010	0.906"	✓		✓	"
0.063 thick	+/-0.010	0.063"	✓		✓	mm01
Grain Direction	N/A		✓			N/A
Ø0.128	+0.005/-0.001	0.129"	✓		✓	mm01
Ø0.172	+0.005/-0.001	0.174"	✓		✓	"

Measured by: JM	Audited by: S	Prototype Approval:	N/A
Date: 12-7-7	Date: 12/6/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM	

Dart Aerospace Ltd

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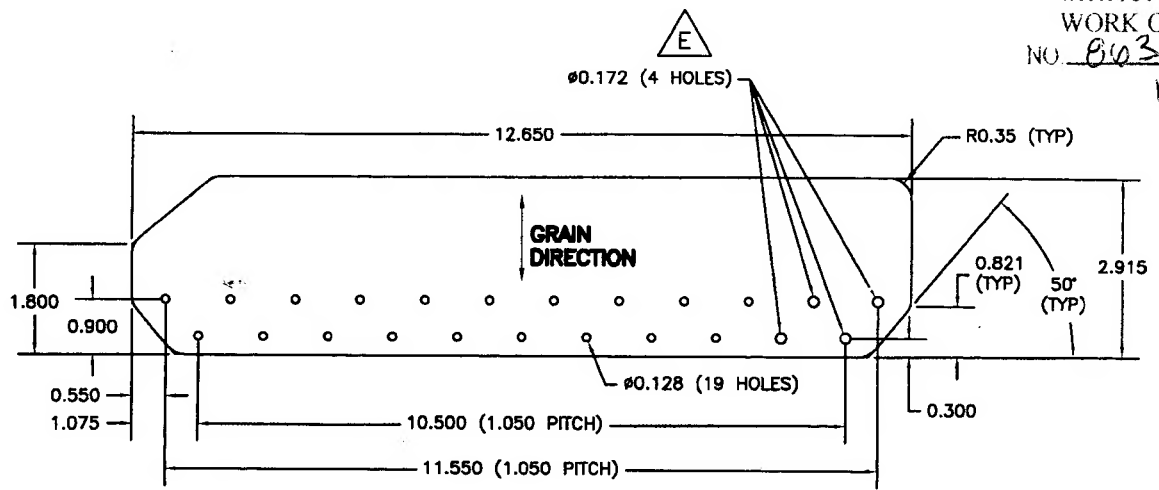
NOTE: Date & initial all entries



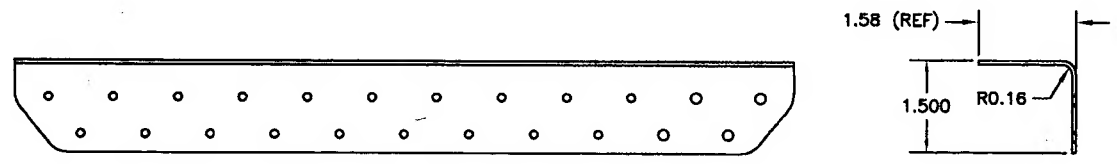
RELEASED
26 10 13

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 80358 MLJ
12/06/28

DESIGN	RF	DRAWN BY	DATE	CHECKED	APPROVED	DRAWING NO.	TITLE	SCALE
		CE	06.09.25	PH		D2175	ANGLE	1:3
A		95.10.25				NEW ISSUE		
B		96.01.18				CHANGED DIMENSION		
C		00.09.11				UPDATE FINISH SPEC		
D		04.06.03				RE-DESIGN		
E		06.09.25				INC HOLE DIA TO Ø0.172, 4 HOLES		



D2175-1F FLAT PATTERN



D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)

- NOTES:
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 5) ALL DIMENSIONS ARE IN INCHES

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